

Date: Monday, 3/26/2007 3:27:05 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 31503	
Estimate Number : 10260	
P.O. Number : N/A	Part Number : D23623
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E1
Previous Run : 30877	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 4/30/2007 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: G 00.05.18 Added inspection level 8 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 Step Support  
 Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	B29807

mk 07/03/27 10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

mk 07/03/28 16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

mk 07/03/28 10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EG 07-03-28 10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

SDD 07/04/01 10

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
 Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

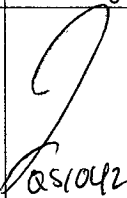




touch ups. FK 07/04/03 10

m103706

FK 07/04/02 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 27/04/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-04-02	6.0	Paint missing inside of bracket.	 05/04/02	Re-powder coat; ensure <del>part</del> full coverage.	 07/04/03	 07-04-03	 05/04/02	 07-04-02

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:27:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 31503

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF

07-04-04

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B30971-

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B30972-

MF 07-04-04

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement

as per Dwg D2362

Batch ~~M19738~~

M102565

MF 07-04-04

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

07/04/04

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

store

07/04/04

(10)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/04

Job Completion



07.04.10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**DART**



**RELEASED**  
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 1 OF 3
		SCALE
		1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

**UNDER REVIEW**

01.03.15 CP

DESIGN OK, BUT CHECK WITH  
35 BEFORE MANUFACTURE  
OK 01/03/04

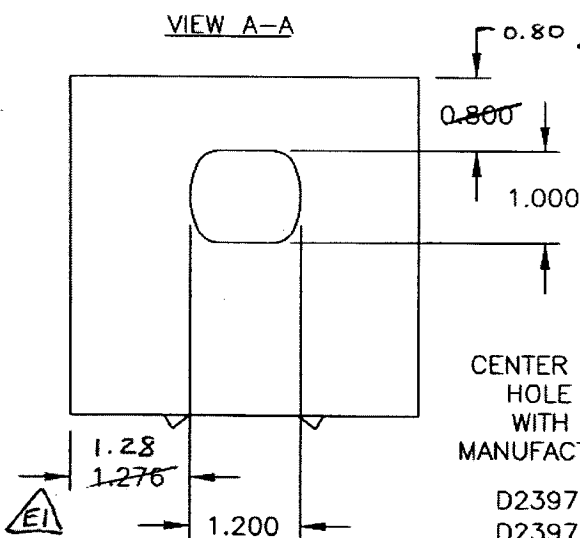
0.257 X 0.75 SLOT

REMOVE TIPS  
FROM CASTING  
MAX 0.080

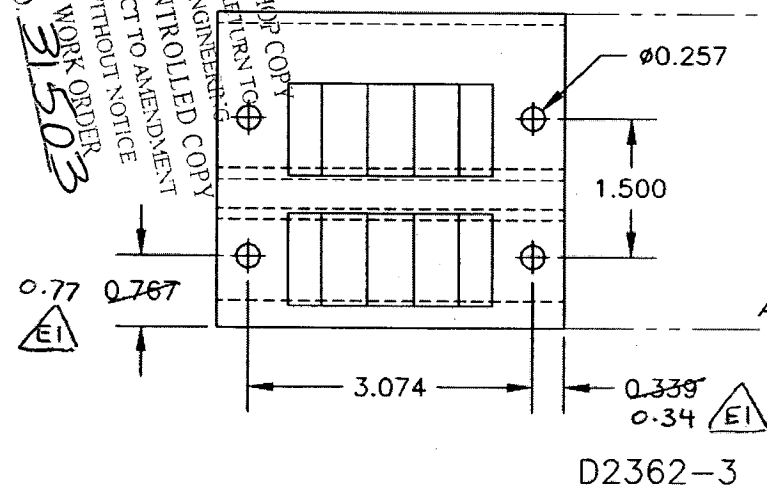
CENTER D2397-1/-3 RUBBER  
HOLE WITH SLOT AND BOND  
WITH CONTACT CEMENT PER  
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)  
D2397-3 RUBBER CUSHION (1)

VIEW A-A



UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31503



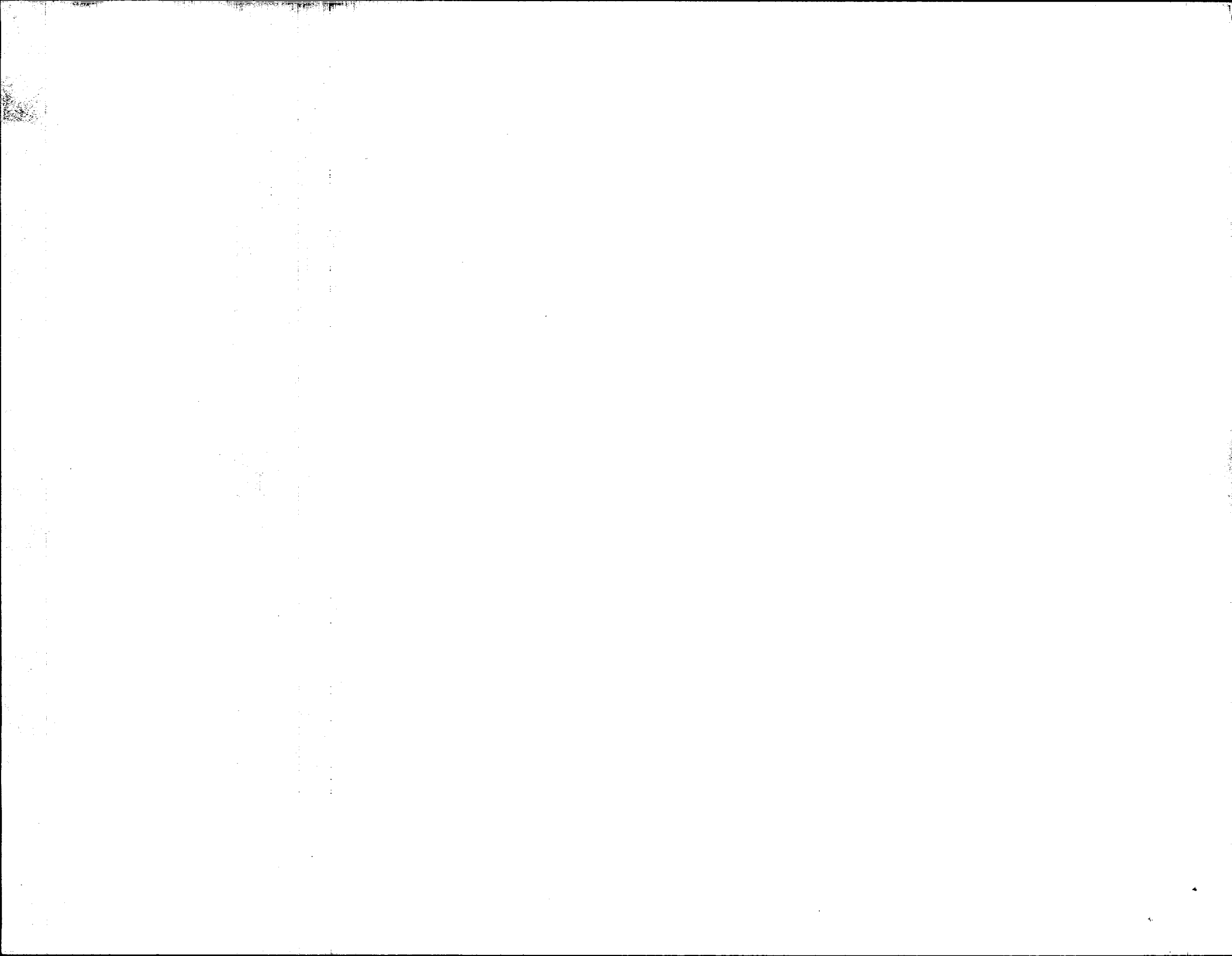
D2362-3

**NOTES:**

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE

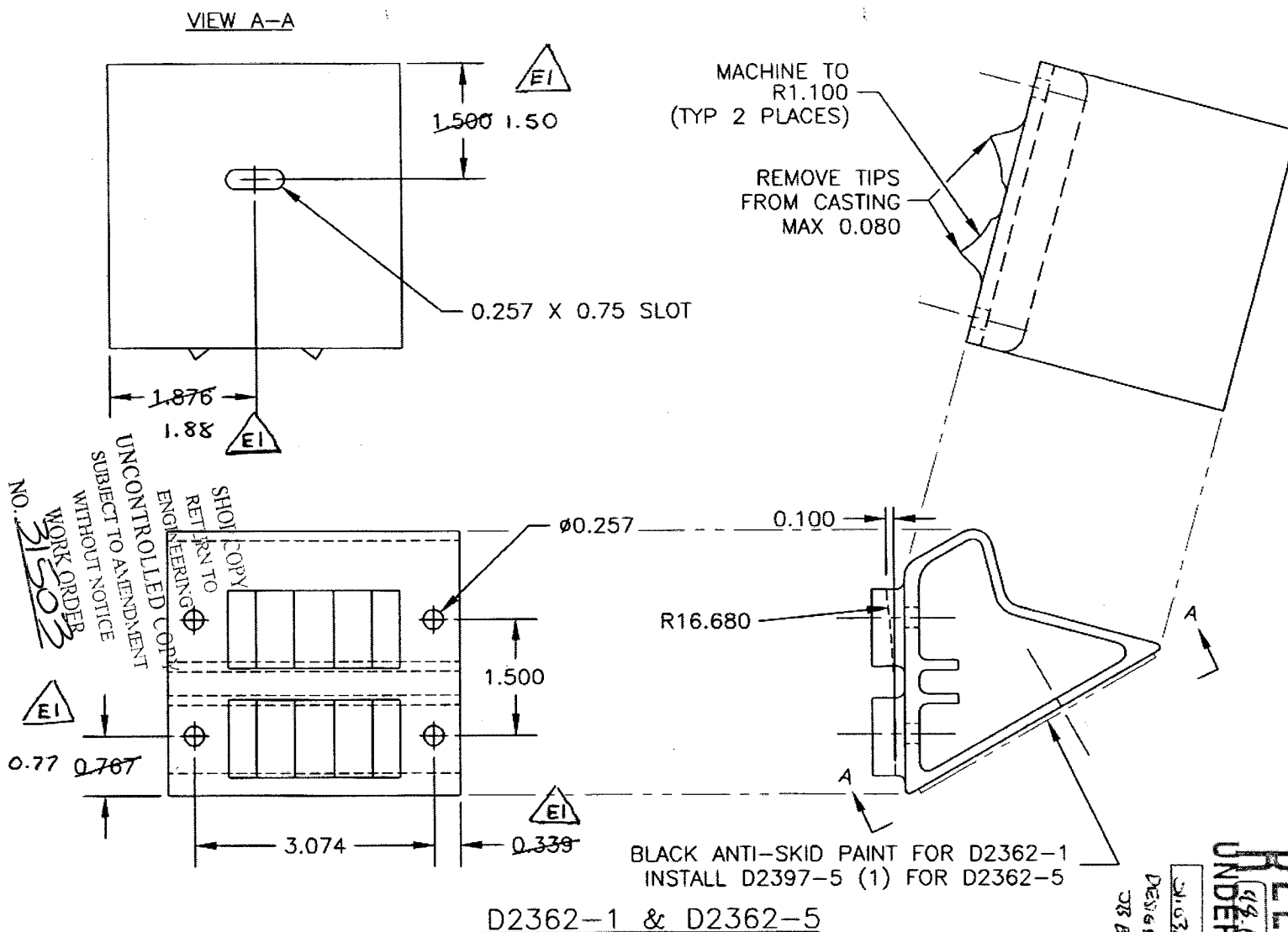
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED







DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED CP	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 2 OF 3
	SCALE 1:2	



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT  
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAMKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED KE	REV. E
DATE 98.12.04	DRAWING NO. D2362	SHEET 3 OF 3
	TITLE STEP SUPPORT BRACKET	SCALE 1:2

UNDER REVIEW

01.03.15 CP

DESIGN OK BUT CHECK WITH  
DTS BEFORE MANUFACTURE

RELEASED  
98.12.14 KB

3.750 (REF)

REMOVE TIPS  
FROM CASTING  
MAX 0.080

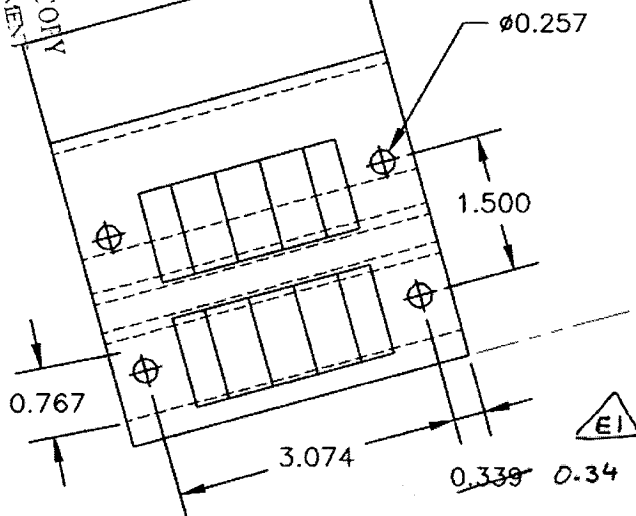
BLACK ANTI-SKID PAINT

D2244-3.75

WELD PER DART 1/8  
QSI 004

D2362-7

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31503



D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED